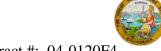
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 82.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William **Report No:** WIR-026973 Address: 333 Burma Road Date Inspected: 29-Dec-2011

City: Oakland, CA 94607

OSM Arrival Time: 600 **Project Name:** SAS Superstructure **OSM Departure Time:** 1430 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Westmont Industries **Location:** Santa Fe Springs, CA

CWI Name: Chris Concha **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS: Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** Maintenance Travelers

Summary of Items Observed:

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

This QA Inspector was informed by WMI Mr. George Grayum that WMI had received some miscellaneous materials for the Travelers. Mr. Grayum presented QA with material test report. QA Inspector reviewed Material Test Reports (MTR's) and checked physical condition of the components to be used for this project, verifying heat number and quantity. Materials inspected contained heat numbers as well as dimensions and material type. Details of materials inspected and approved for use on this project are listed below. QA Inspector issued Caltrans lot number B208-042-11 for OK to cut components and on the MTR as authorization and materials traceability purposes. The test results and conclusions indicated herein were based on random inspections and observations as described in this report. These documents are included as part of this report. Note: Domestic materials.

Materials Inspected & Approved (OK to Cut B208-042-11) MATERIAL DESCRIPTION – angle- 6" x 3-1/2" x 5/16" x 20' – ASTM A36 HEAT No. / MFR – L80168 / ArcelorMittal, Laplace, Louisiana QUANTITY - 1 ea

E2/E3 EB Traveler

This QA Inspector randomly observed WMI production fitter Mr. Cesar Canales WID #3195 performing layout and fit-up for welding piping brackets to the E2/E3 EB Traveler. No welding performed on the SAS-WB Traveler

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

on this date.

SAS Travelers Supplementary Platforms

This QA Inspector made random shop observations and observed no fit-up performed on the SAS Travelers Supplementary Platforms Assemblies on this date.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to continue coat applications on Maintenance Travelers. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to sweep blast SAS EB/WB Balconies, Traveler Trolley Links, Anti-twist assemblies today. Later in the morning this QA Inspector randomly observed that RPI personnel performing abrasive blasting activities on the above mentioned components. Mr. Keen stated that RPI will not apply the Zinc Clad II plus prime coating the SAS EB/WB Balconies, Traveler Trolley Links, or anti twist beams today. QA Inspector informed to Mr. Keen that RPI will be proceeding at their own risk pending acceptance of the sample test results. Mr. Keen stated that he is aware the RPI is proceeding at their own risk. After sweep/spot blasting was completed, QA Inspector then observed Mr. Keen performing random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Keen utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.2 mils, 3.3 mils, and 3.5 mils. QA Inspector then observed Mr. Keen perform a test for soluble salts on the previously blasted base metal surface. Testing observed by QA Inspector appears to be in compliance with the contract requirements. Note #1: The SAS EB/WB Balconies had been previously abrasive blasted and prime coated, but due to balcony modifications, balconies were re-blasted. Note #2: The Traveler Trolley Links had been previously abrasive blasted, prime and top coated, but due to Traveler brake modification, links were re-blasted in preparation for welding.

Later in the shift, this QA Inspector randomly observed RPI Coating performing what appeared to be primer application activities within what appeared to be within and 8 hour time frame form the above mentioned sweep blasting activities. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 47/80 F, Relative Humidity 52/48%, Wet Bulb Temperature 39/68 F, Dew Point 30/61 F and Surface Temperature 46/67 F.

This QA Inspector randomly observed RPI Coating personnel sanding dry spray or overspray on SAS WB Traveler fixed stairs middle section of the lower truss in preparation for testing and applying the mist/top coat application. QA observed RPI using 80grit sandpaper. After sanding was completed QA Inspector observed RPI Coating personnel water rinsing sections mention above with a minimum pressure of 35Mpa/5,077 PSI pressure washer.

QA Inspector sampled of parts A, part B, and part F, of Sherwin Williams Zinc Clad II Plus Inorganic Zinc-Rich Coating representing 1 kit. QA Inspector assigned Caltrans Lot #B208-044-11 and TL-101 #712430.

This QA noted above items observed appear to comply with contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon,Sherri	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer